

**Work Order ID 63946**

Page 1

Friday, November 19, 2010 1:36:33 PM

Item ID: D4055-5

Accept



Setup Start



Revision ID:

Item Name: Tank Upper Cut Out

Stop



Start Date: 11/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MLFDate: 10-11-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4055

A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 12965  
Purchase part as per Dwg D4055  
Possible Supplier: GFI  
Material release note requiredCY 10/11/19 (3)

110

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ref 12/2 (4)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/10/12/21(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ M 10/12/21



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

H 10.12.23 H BK 10.12.21

150

Identify as per dwg &amp; Stock Location: SE

0.00



Packaging

Memo

0.00

Packaging

H 10.12.23 4

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/03

11.01.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, November 19, 2010 1:36:33 PM

Page 1

Work Order ID: 63946



Parent Item: D4055-5



Parent Item Name: Tank Upper Cut Out


Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-5P  Tank Upper Cut Out		Purchased	No			110	Each	0.0000	1	1			



*[Signature]* (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

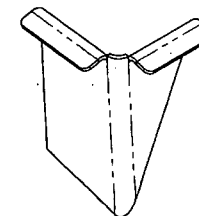
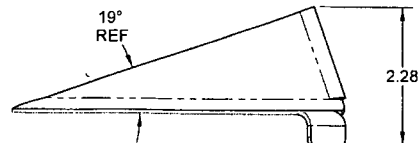
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

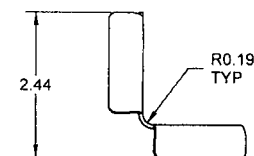
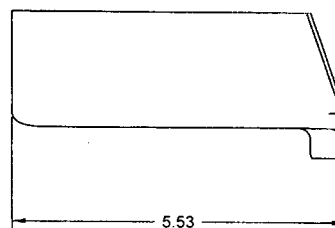
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**NOTE:** Date & initial all entries





#63946



# D4055-5 UPPER CUT OUT

**RELEASED**  
2010-05-05  
MD

## NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4055</b>	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	10.04.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR REPRODUCED IN ANY MANNER OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

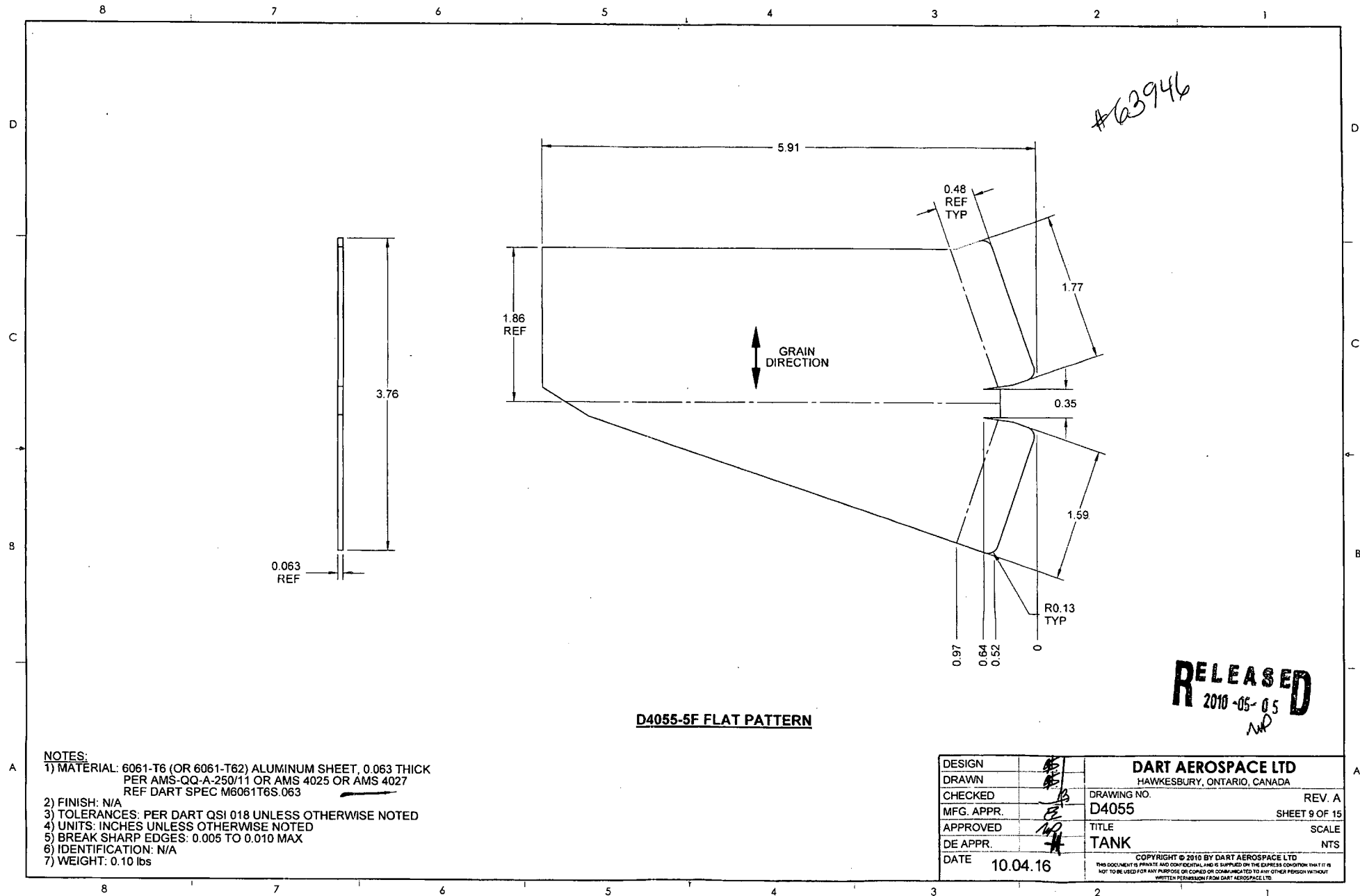
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**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO12965

Purchase Order Date 11/19/10

PO Print Date 11/23/10

Page Number 1 of 1

Order From :

VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

**FAXED**  
11/23/10

Contact Name

Vendor Phone 514 630 4877

Vendor Fax 514 630 4849

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Currency

FOB

Chantal Lavoie

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**REVISED**

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
3	D4055-5P	Tank Upper Cut Out	12/13/10 Yes	4.00 Each	Purolator ground	\$115.0000	\$460.00
Special Inst:			MANUFACTURE AS PER DWG D4055 REV. A B63946				
5	D4055-9P	Tank Back	12/13/10 Yes	3.00 Each	Purolator ground	\$115.0000	\$345.00
Special Inst:			AS ABOVE B63948				
6	D4055-11P	Tank Front and Bottom	12/13/10 Yes	✓ 2.00 Each	Purolator ground	\$115.0000	\$230.00
Special Inst:			AS ABOVE B63944				

PO Total:

\$1,035.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr: 5

Change Date: 11/23/10

CL  
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



180 AVENUE LABROSSE  
POINTE-CLAIRE, QC, CANADA H9R 1A1  
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



## BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO	PAGE
JR - DY	MO - MO	AN - YR		
17	12	10	0452439	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR SHIP VIA
DART		GFI-0299	0223791	PO12965
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO		DESCRIPTION	

4 D4055-5P

TANK UPPER CUT OUT

CERTIFICATE OF CONFORMANCE REQ

MFG. JOB# J0223791-001QTY 4



EXPÉDITEUR  
SHIPPER

N° DE BON DE LIVRAISON  
SHIPPING MEMO NO



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>2</u>		OUR JOB NO <u>J0223791</u>		SHIPPING MEMO <u>0452439</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>-</u>	<u>4 PCS</u>	<u>PO12965</u>	<u>D4055-5P</u>	<u>A</u>	<u>TANK UPPER CUT OUT</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO	
<u>AL 6061-T6</u> <u>(AMS-QQ-A-250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>371069</u>	
PROCESS			PROCESSOR		RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>		<u>GFI</u>		<u>N/A</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0223791-001 (4 PCS)</u>				
3					
4					
5					
6					
7					
8					
9					

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 17 DECEMBER 2010

G.F.I. Q.C. REP. *Carton Bond*



# LES MÉTAUX SPÉCIALISÉS SAMUEL

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2008 + AS9100B

## LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

**Date:** DECEMBER 01,2010

**Company Name:** GFI Division of Thomas & Betts limited  
**Address:** 180 avenue Labrosse  
**City:** Pointe-Claire Qc  
**Zip Code:** H9R 1A1

**# du client:** 0077675

**# de commande SSMQ:** 012204

**Customer's order #:**


**SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	2	.063" X 48" X 144"	6061 T6	AMS-QQ-A-250/11	371069

Bien à vous,  
Yours truly,







# CERTIFIED INSPECTION REPORT

Alcoa Inc.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Malcolm Murphy  
Director of Manufacturing Davenport Works

Kenton P. Young  
Quality Assurance Manager

PITTSBURGH, PA Ship From: RIVERDALE, IA.

1163116 Ship Date 0 B.L. No. Invoice No. Alcoa No. Item Page 1  
2010-09-11 5158005 00000 1000221841-1 DCE-21841-1  
P.O. No./Govt Contract No. Customer Alcoa Item  
C62699 Ln#: 1 SAMUEL SON & CO LT G041110647R05

Ship To: SAMUEL SON & CO LTD  
S.S.M.Q  
21525 CLARKE-GRAHAM  
BAIE D'URFE H9X 3TS QC

Item Description  
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -  
.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-  
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE  
GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-  
209 REV 07 EXC MRK ASTM B209 REV 07  
CMMPO25 REV S ((MARKED)) KRAFT PAPER  
INTERLEAVED MAX GROSS  
SKID WGT: 4500 LB QUAN TOL +/-30 %  
CQR 0222751 REV 04 CUST REQ 10-09-  
07 \*\*\* W/E 10-09-11 \*\*\*



Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	239163	371069	1609	40	PC	27088 47004
2	239166	371069	4061	100	PC	27088 47004
3	239168	371069	4061	100	PC	27088 47004
			9731	240		

Notes for CQR: 0222751.4  
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250\_11 ORIGINAL REVISIO N DATED 1997-08-01.  
CQR: 0222751.4 -Specification Limits -----

Temp Dir	UTS KSI	TYS KSI	EL4D PCT
T6 Long Transv.	Max		
	Min	42.0	35.0 10

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05
	Min	0.40		0.15		0.8	0.04			

REMAIN

# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS  
Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of this material met the composition limits and had the mechanical properties shown on the face of this sheet.

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Director of Manufacturing Davenport Works

Kenton P. Young  
Quality Assurance Manager

1163116 0  
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2010-09-11 5158005 00000 1000221841-1 DCE-21841-1  
P.O. No./Govt Contract No. Customer Alcoa Item  
C62699 Ln#: 1 SAMUEL SON & CO LT G041110647R05

CQR: 0222751.4 -Specification Limits (cont.)  
Lot: 371069 - Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	51.1 ✓	45.7 ✓	10.4 ✓
			50.8	45.3	10.3

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9795095	Actuals	0.66 ✓	0.4 ✓	0.28 ✓	0.03 ✓	1.0 ✓	0.20 ✓	0.03 ✓	0.02 ✓

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

